

**Amendments to and Listing of the Claims:**

Please *cancel claims 1-27 and 32-36* and *amend claim 28*, all without prejudice, as shown below in the following listing of all claims ever presented. The following listing of claims replaces all prior versions thereof.

1-27. (Canceled)

28. (Currently Amended) A sputtering target comprising:

- (a) a pot having a refractory metal component; and
- (b) a collar attached to the pot; wherein the pot is made by a process

comprising:

- (a) cutting an ingot comprising a refractory metal component into a cylindrical first work piece;
- (b) subjecting the first work piece to upset forging, and thereby forming a second work piece;
- (c) subjecting the second work piece to a first annealing step in a vacuum or an inert gas to a first temperature that is sufficiently high to cause at least partial recrystallization of the second work piece, and thereby forming an annealed second work piece;
- (d) forging-back the annealed second work piece by reducing the diameter of the second work piece, and thereby forming a third work piece;
- (e) subjecting the third work piece to upset forging, and thereby forming a fourth work piece;
- (f) forging back the fourth work piece by reducing the diameter of the fourth work piece, and thereby forming a fifth work piece;
- (g) subjecting the fifth work piece to a second annealing step to a temperature that is sufficiently high to at least partially recrystallize the fifth work piece;
- (h) subjecting the fifth work piece to upset forging, and thereby forming a sixth work piece;

(i) subjecting the sixth work piece to a third annealing step, and  
thereby forming an annealed sixth work piece;

(j) rolling the annealed sixth work piece into a plate by subjecting the  
annealed sixth work piece to a plurality of rolling passes; wherein the annealed sixth work piece  
undergoes a reduction in thickness after at least one pass and the annealed sixth work piece is  
turned between at least one pass, and thereby forming a plate; and

(k) deep drawing the plate into a pot, thereby forming the pot;  
wherein a fourth annealing step is carried out either (1) after step (j) before step  
(k), or (2) after step (k),

wherein the upset forging and forging back of the work pieces is carried out such  
that the diameter of the work piece in each instance is increased or reduced, respectively by upset  
forging and forging back, relative to a longitudinal axis of the cylindrical first work piece, and

wherein dimensions of at least one work piece or plate suitable for processing into  
a pot are pre-determined with a computer-implemented finite element modeling assessment  
method so that at least one work piece in steps (b)-(j) or plate in step (k) has dimensions that are  
substantially similar to the dimensions determined by the computer-implemented finite element  
modeling assessment method.

29. (Original) The sputtering target of Claim 28, wherein the collar is welded  
to the pot.

30. (Original) The sputtering target of Claim 28, wherein the collar is made  
from a refractory metal component or a metal that can be welded to the pot material in such a  
way as to give a joint free from cracks.

31. (Original) The sputtering target of Claim 28, wherein the collar is made  
from a refractory metal component is selected from the group consisting of (a) niobium, (b)  
tantalum, (c) niobium alloys, (f) tantalum alloys, and combinations thereof.

32-36. (Canceled)